

# Work Order ID 55829

February 3, 2010 8:22:19 AM

HAI ASAP



Item ID: D3705-7

Accept



Setup Start



Revision ID:

Stop



Item Name: MAIN PANEL

Start Date: 2/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: u

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
	C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705 11 Dwg Rev: C 11 Prog

Rev: C 12- Debur if necessary

MAT NOT PULLED

HB 10-2-3

6061-063

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 10-2-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/2/03

⑦

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

u/s

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

=> 14

10/02/03

(X)

Ø

# Work Order ID 55829

February 3, 2010 8:22:20 AM



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Item ID: D3705-7

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Setup Start



Revision ID:

Stop



Item Name: MAIN PANEL

Start Date: 2/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

⇒ M 10-02-04 (X) ✓

Powder Coating

START TIME: 11:00am OVEN TEMPERATURE:  
11:30am FINISH TIME: 3209

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-02-4

①

Quality Control

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

1/1/11 Size

**Work Order ID 55829**

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Item ID: D3705-7

Accept



Setup Start



Revision ID:

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Item Name: MAIN PANEL

Start Date: 2/03/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/09  
MF

10-2-4

00700 fcb

# Picklist Print

February 3, 2010 8:22:18 AM

Page 1

Work Order ID: 55829



Parent Item: D3705-7



Parent Item Name: MAIN PANEL

Start Date: 2/03/10

Required Date: 2/05/10

Comments: IPP Rev:A 09-01-09 rev.c as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	302.8841	0.3500			



6061-T6 .063 Sheet



B 10-2-3

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

302.8841211

110551

25.2841211

113608

277.6

112 939

112 939

①

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 55829
<b>Description:</b> MAIN PANEL	<b>Part Number:</b> D3705-7
<b>Inspection Dwg:</b> D3705-7 <b>Rev:</b> C	<b>Page 1 of 1</b>

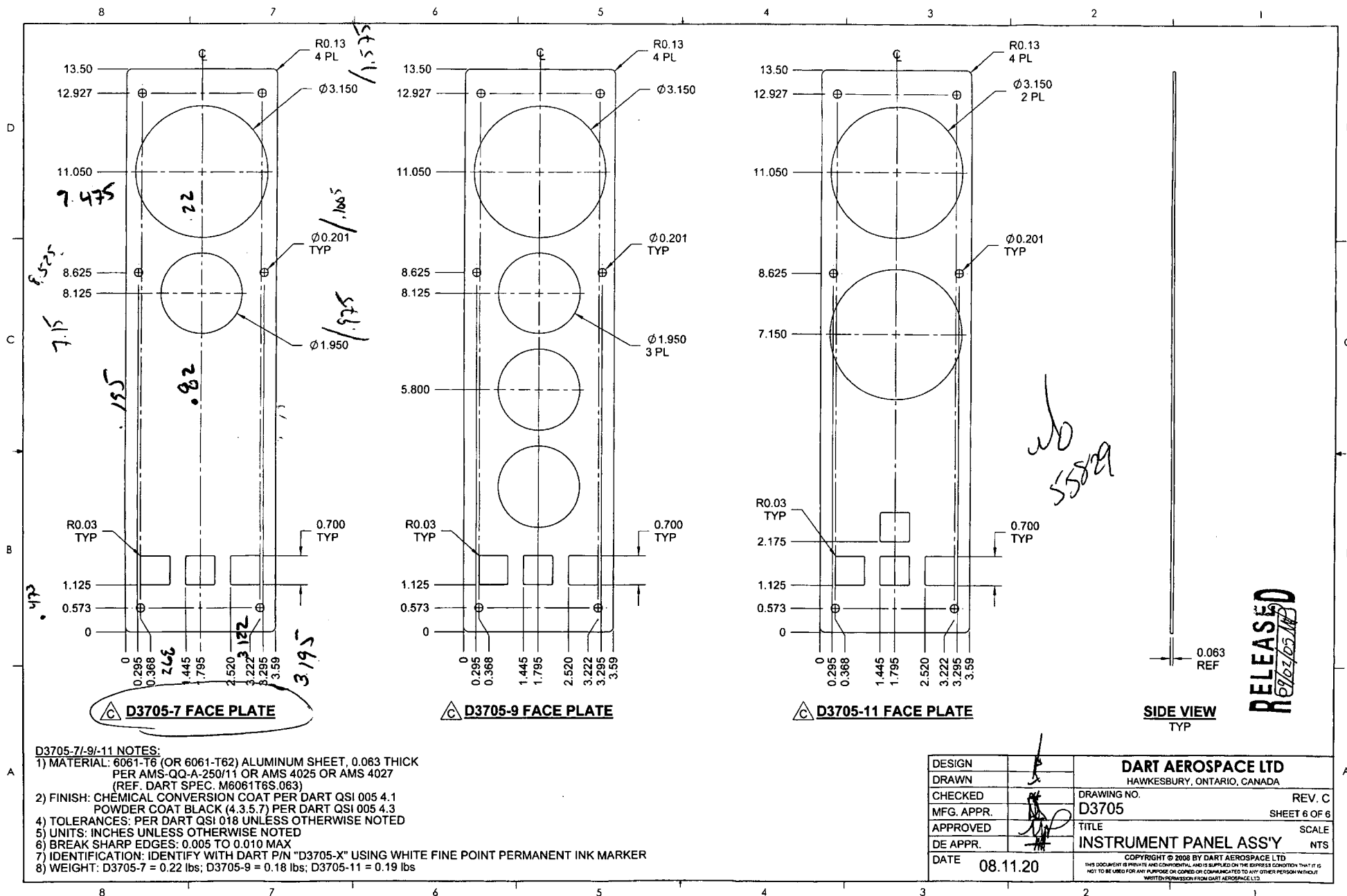
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201	+ .005 - .001	.205	X			
Ø 1.950	+ .012 - .001	1.954	X			
Ø 3.150	+ .012 - .001	3.154	X			
.295	+/- .010	.293	X			
.368	+/- .010	.370	X			
1.445	+/- .010	1.449	X			
2.520	+/- .010	2.527	X			
3.222	+/- .010	3.225	X			
3.295	+/- .010	3.294	X			
3.59	+/- .030	3.598	X			
.700	+/- .010	.704	X			
.573	+/- .010	.570	X			
1.125	+/- .010	1.119	X			
8.125	+/- .010	8.125	X			
8.625	+/- .010	8.625	X			
11.650	+/- .010	11.051	X			
12.927	+/- .010	12.927	X			
13.50	+/- .030	13.50	X			
.063	+/- .010	.060	X			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-2-3	<b>Date:</b> 10/02/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3705</b>	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>INSTRUMENT PANEL ASS'Y</b>	NTS
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